

Date: Thursday, 6/21/2007 2:34:40 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CROSSBOLT SPACER		
Job Number	33081	Part Number	D2579		
Estimate Number	10993	Drawing Number	D2579 REV D		
P.O. Number	N/A	Project Number	N/A		
This Issue	6/21/2007	S.O. No.	N/A		
Prsht Rev.	NC	Type	MACHINED PARTS		
First Issue	N/A	Material	N/A		
Previous Run	33057	Due Date	7/10/2007	Qty:	200
Written By		Um:	Each		
Checked & Approved By					
Comment	Est E 02.06.17	Now turned on Cobra	NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W	
		Comment: Qty.: 0.3762 f(s)/Unit Total : 75.2430 f(s) 6061-T6 Tube .500 x.058W Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) 0.500 Dia x 0.058 Wall	Batch 10542 DSP 07/07/22
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA245	DSP 07/07/22
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	DIP 07/07/22
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	JL 07/07/22
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 26	BF 07/07/23
6.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	D 07/07/23
		Job Completion	JL 07/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33081
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

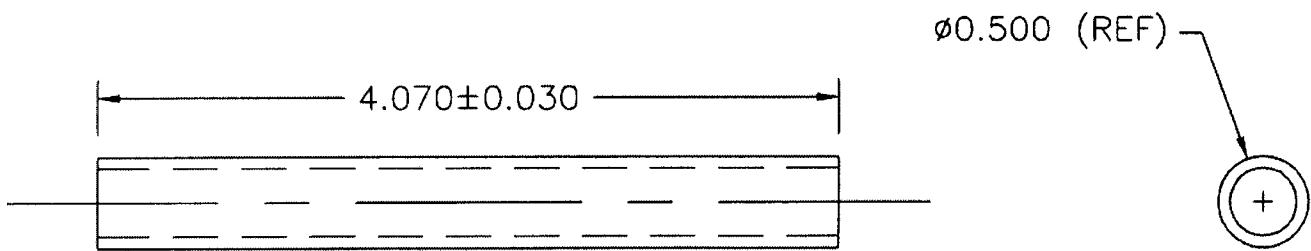
Measured by: <u>DJP</u>	Audited by: <u>J.L.</u>	Prototype Approval: <u>N/A</u>
Date: <u>07/07/22</u>	Date: <u>07/07/22</u>	Date:

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF ✓	PF



DESIGN <i>DM</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>RE</i>	DRAWING NO. D2579	REV. D SHEET 1 OF 1
DATE 99.05.19		TITLE CROSS BOLT SPACER	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	96.12.05	0.065 WALL WAS 0.035 WALL	
C	97.02.21	0.058 WALL WAS 0.065 WALL	
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)	

RELEASED
99.05.20 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33081

MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.500 DIA x 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED